



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71059

Tuesday, June 21, 2011 1:32:17 PM



Page 2

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*aml 11/07/13*

*4* *8*

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*4x 8 M-11/07/13*

155

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B *117319*  
DELFLEET BLUE B *118395*  
DELFLEET CLEAR B *118053*

*85 11-07-26 (K4)*

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**Work Order ID 71059**

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Page 3

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165  QC Quality Control	QC14- Inspect Spray Paint  Memo	0.00  0.00				<u>nl</u>	<u>11</u>	<u>57</u>	<u>27</u> (4)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>420</u>  Memo	0.00  0.00							<u>11/7/27</u> (4)
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>11/7/27</u> (4)

11/07-27  
(4)

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, June 21, 2011 1:32:27 PM

Page 1

Work Order ID: 71059

Parent Item: D2938-2

Parent Item Name: Saddle RH Out, 206



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC ☐  
IPP Rev: C As per Rev C 07-03-19 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	31.0000	1	4			
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Saddle Billet, 7075



JL 11-07-12

Location

Loc Qty

Loc Code

MAT

5

69701

5

MAT040

20

69678

20

MAT45

6

68172

6

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	71059
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.118	.120	.119		
B	0.100	0.140		.119	.118	.119	.119		
C	0.100	0.140		.110	.114	.112	.111		
D	0.210	0.230		.220	.220	.219	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.502	.501	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.250	.249	.249		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.259	1.261	1.259	1.260		
Y	1.565	1.585		1.574	1.575	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	11-07-13

Audited by:	mf
Date:	11/07/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

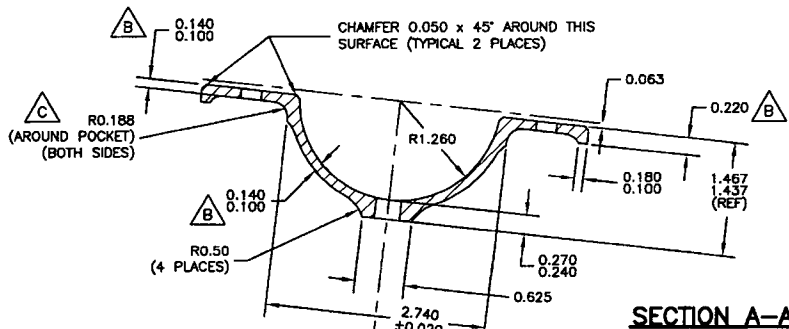
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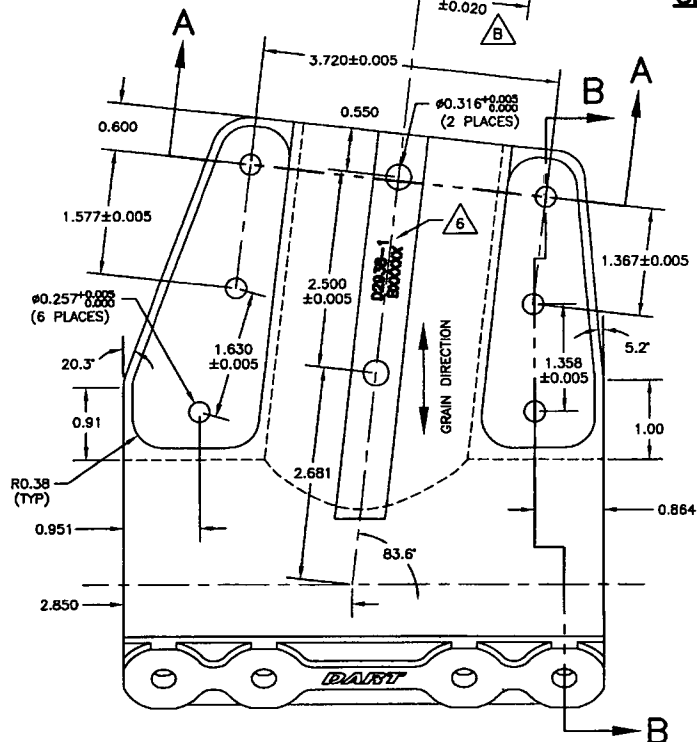
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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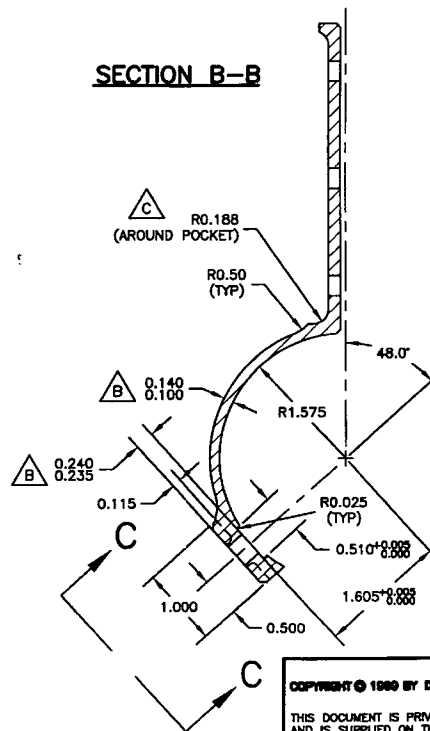
**NOTE:** Date & initial all entries



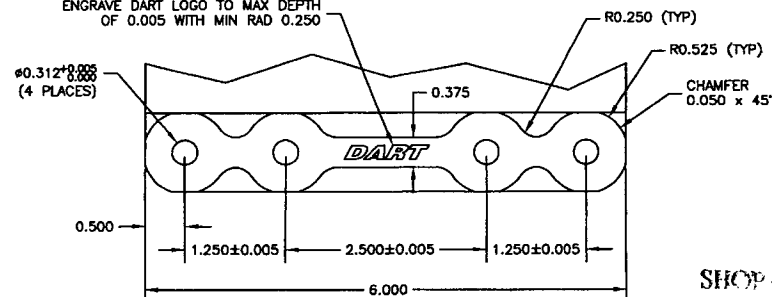
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMEND  
WITHOUT NOT  
WORK ORDL

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NO. 71009

06.11.09

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE 2:3
06.11.09	SADDLE OUTSIDE	

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RELEASED

07.02.12

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